

Date: Thursday, 29/06/2006 9:05:43 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 27773	
Estimate Number : 12481	
P.O. Number : N/A	Part Number : D35201
This Issue : 29/06/2006 S.O. No. : N/A	Drawing Number : D3520 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : PREL
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 30/06/2006 Qty: 2 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 06-06-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01000	6061-T6 Bar .50" x 1.0"
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Comment: Qty.: 0.1218 f(s)/Unit Total : 0.2436 f(s)

6061-T6 Bar .50" x 1.0"

(M6061T6B0500X1000)

Batch: 1718133

ML 06/06/29

2

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks 1.400" long

ML 06/06/29

2

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA646 Rev: AA & Dwg D3520 Rev: A

2-Deburr per dwg D3520

ML 06/06/29

2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/06/29

2

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06/06/30

2

Date: Thursday, 29/06/2006 9:05:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27773

Part Number: D35201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA

SC 06 06 30

(2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MA

SC 06 06 30

(2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA

06 06 30

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: /

U

06-06-30

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(2)
06/06/30

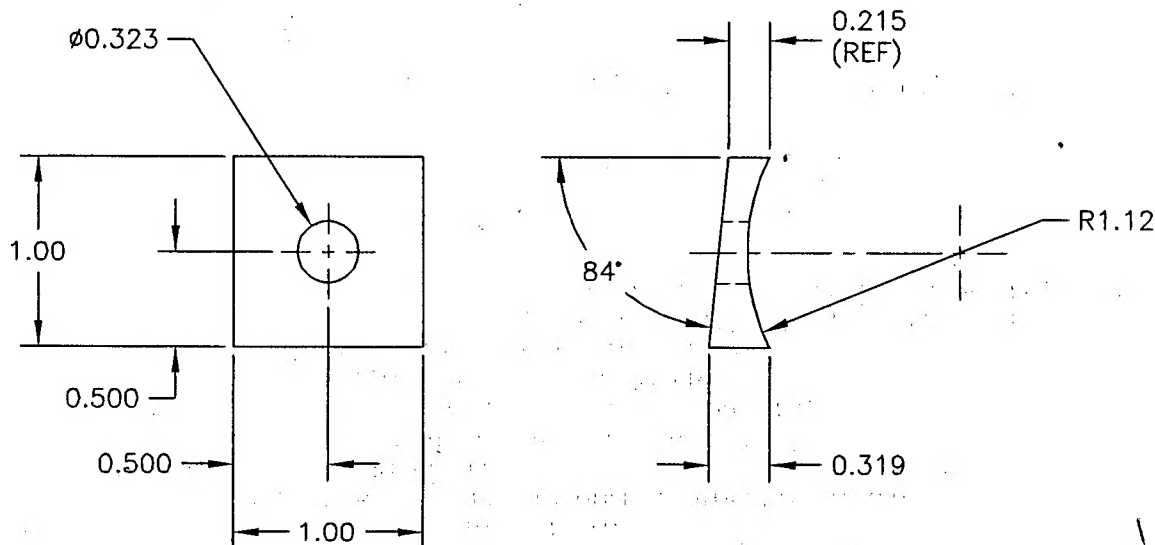
Job Completion



U 06-06-30

PRELIMINARY ISSUE

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3520	REV. A SHEET 1 OF 1
DATE 06.06.28		TITLE (A119 BASKET) SPACER	SCALE 1:1
A	06.06.28	NEW ISSUE	



D3520-1 SPACER

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

1/2" x 1"
Blank
1.400
6061

L Lacelle

From: Jean Luc Menard [jmenard@dartaero.com]
Sent: June 28, 2006 6:55 PM
To: MARC BELLAVANCE (E-mail)
Cc: Linda Lacelle (E-mail)

Marc,

D3520-1 spacer is programmed and ready to go, estimate is done and material is in stock, I leave it to you to organize with LL when to schedule these in.
I had told you I would be making these by hand but we dont have the right cutter to obtain the rad you needed, therefore they will have to go on the cnc.

JLM
Jean-Luc Menard
Production Engineering Coordinator
1270 Aberdeen Street
Hawkesbury Ont
Canada K6A 1K7
Tel: 1-613-632-3336
DART AEROSPACE LTD.



ALCOA EXTRUSIONS, INC.
53 POTTSVILLE STREET
CRESSONA, PA
17929-0187

Alcoa Extrusions, Inc. a subsidiary of Alcoa Inc

Invoice To Customer

COPPER & BRASS SALES INC
P.O. BOX 5116

SOUTHFIELD, MI - 48086
Ship To Customer

COPPER & BRASS SALES INC
1310 SCRIBNER N.W.

GRAND RAPIDS, MI - 49504

Certified Inspection Report

019958

Sales Order Number
1438651 Line No. 1

Customer P/O

CE2762

Cert Number AEP326442	Page 1 of 2
Cert Creation Date 16-APR-05	Cert Print Date 16-APR-05

Quantity Shipped	Date Shipped	Item Description
507 LB	16-APR-05	Extruded Rectangular Bar 0.5 TK x 1 W RAD 144 IN LN 6061 / T6511 FIN M-MILL W/F 0.588 F 05 CS 1.1 Marking CONTINUOUS; ASTMB221 REV 04 AMS-QQ-A-200/8 REV ASMESB221 REV UNS#A96061 REV
B/L	Item No.	
388811	G03361768	
Delivery ID	Item No. Rev	
533485	--	
Customer Part No		
019958		

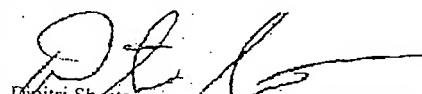
Applicable Specifications, Revisions and Exceptions

TAG: 0207-H

Legal Statement

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition and had the mechanical properties shown on the face of this certification. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in partial form without prior written approval of our Quality Assurance Dept.

Signature And Title


Dmitri Sheets
Tech/Quality Manager
16-APR-05

Quantities per Lot / Packages

Package Number	Lot Number	Quantity	UOM	Weight	
				Gross	Net
GBR-PKG011759	BR14952340	72	PCS	516	507

Composition Limits

Alloy	Si		Fe		Cu		Mn		Mg		Cr	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
6061	0.40	0.8	---	0.7	0.15	0.40	---	0.15	0.8	1.2	0.04	0.35

Alloy	Zn		Ti		Others Each		Others Total	
	Min	Max	Min	Max	Min	Max	Min	Max
6061	---	0.25	---	0.15	---	0.05	---	0.15

SOLD TO Copper & Brass
DATE 7-15-05
CUSTOMER P.O. 2008359
CUSTOMER P/N
SHIPPER NO. 241395
QUANTITY 4 PCS
BY N. J. Hensley
COPPER and BRASS SALES

11/8/33